

Date: Thursday, 24/07/2008 8:24:44 AM  
 User: Melanie Fauteux

## Process Sheet

Duplicate

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 40609 -2  
 Estimate Number : 13434  
 P.O. Number :  
 This Issue : 24/07/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 17/07/2008 Type : LARGE FAB ASSY  
 Previous Run :  
 Written By :  
 Checked & Approved By : MF 08-07-24  
 Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Drawing Name : AFT ADJUSTABLE BLADE SUPPORT ASSY  
 Part Number : PB674300117  
 Drawing Number : B6743001 P.7  
 Project Number : N/A  
 Drawing Revision : B1  
 Material :  
 Due Date : 24/07/2008 Qty: 5 Um: Ea

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001259	Inner Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Inner Tube

batch: 340578

2.0	PB6743001249	Inner Tube Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Inner Tube Bushing

batch: M10591

3.0	PB6743001253	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Gusset

batch: 340045=2 40717=3

4.0	PB6743001254	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Gusset

batch: 340053

5.0	PB674300171	PB67-43001-71
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-71

batch: 340027





Thursday, 24/07/2008 8:24:44 AM  
Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40609

Part Number: PB674300117

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

*Handwritten:* 08-07-24

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*Handwritten:* PD 08-07-24 (5)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* S 08/07/29 (48)

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

HELICAL INSERT

*Handwritten:* M17935

*Handwritten:* BK

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- tap drill for helicol

3- install helicol insert as per dwg

*Handwritten:* BK 08-07-30

*Handwritten:* (5)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* S 08/07/30 (45)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Handwritten:* N/A

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*Handwritten:* M102316

*Handwritten:* (5X)

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

*Handwritten:* M-A 08/07/31





## Process Sheet

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Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40609

Part Number: PB674300117

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00  
320 OF  
1:30

M-A 08/07/31

(5)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/07/31

(5)

15.0

PB674300173

20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

20 Degree Cover Plate

batch: 40094

was done for 2 only

08.08.26

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-83

batch: 40096

see split

08.08.26

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Screw

batch: 18836

08.08.26

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

WASHER

batch: 106242

08.08.26

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

08.08.26



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40609

Part Number: PB674300117

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/10/23 (F2)



21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

card 508/10/23 (F2)



22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



MF 508-10-23

